

Date: Thursday, 2/23/2006 10:24:23 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOLDING STEP WELDMENT **RH**
 Job Number : 25927
 Estimate Number : 10697
 P.O. Number : N/A Part Number : D3388042
 This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D3388 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 25874 Material : N/A
 Due Date : 3/28/2006 Qty: 3 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est. B 05.06.10 Added Step 11 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

D2622-120C extrusion

Batch: 324563

SE 06.03.21 3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CUT D2622-120C extrusion 85.15" long as per Dwg D3388

Deburr and bevel ends for welding

SE 06.03.21 3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>324402</u>

SE 06.03.21 3

4.0 D33872 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	<u>326162 = (2)</u> <u>324120 = (2)</u> <u>325934 = (2)</u>

SE 06.03.22
SE 06.03.24 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 24/05/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 25927

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024.

Grind end cap welds flush

Dwg Rev: A

FC 06.3.24 1
FC 06.3.22 2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

FC 06.03.26 3 PTO see last page

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.4

Wing Walk as per Dwg D3388 and QSI 005 4.4

Powder coat gloss white
As per QSI 005 4.3 (0.5.1) Feb 07 26

FC 060413 3
DC 060413 3

8.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808 Spacer

Press spacer into D3387-2 arm as per Dwg D3387

~~D2808~~ B25248

SAD 06104122 3

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06.04.23 3

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06:05:16 3

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 060511 3
U 060511

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

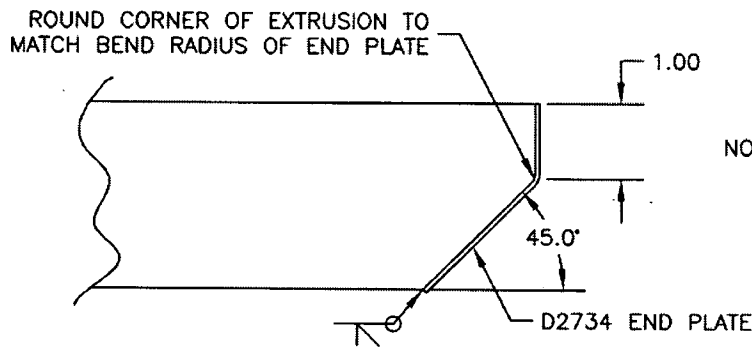
NOTE: Date & initial all entries



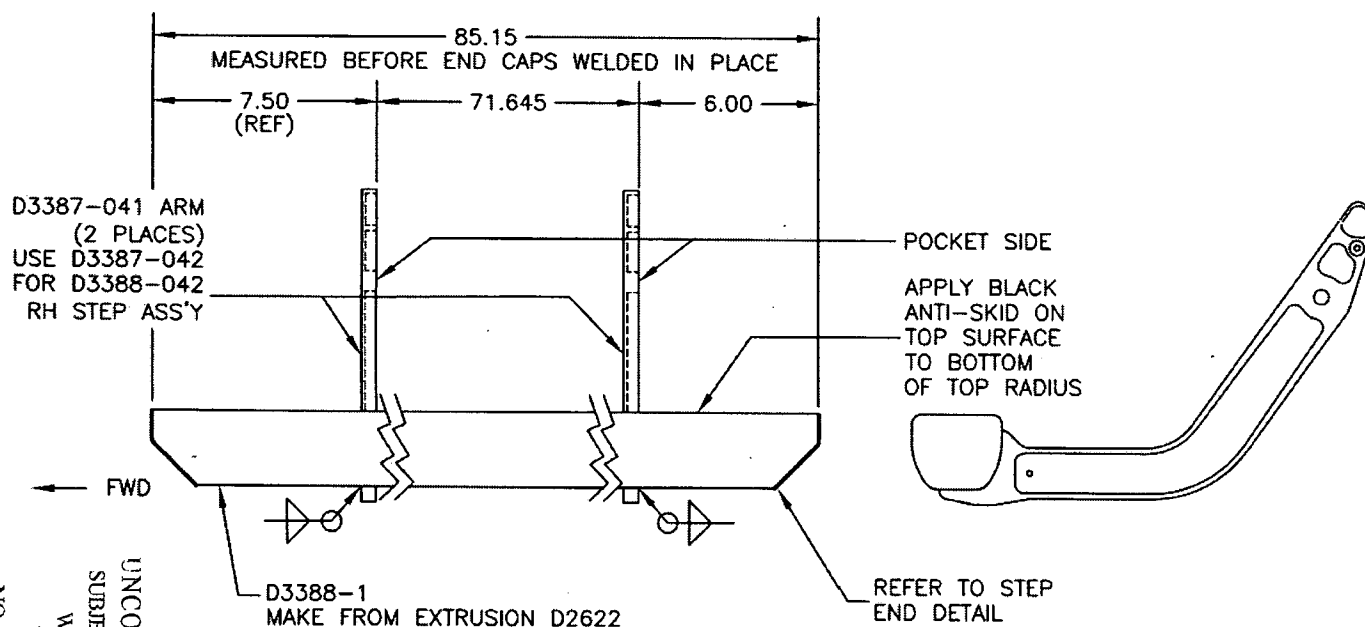
RELEASED

05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2. WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
3. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
05.01.20	05.01.20	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3388	SHEET 1 OF 1
DATE	TITLE	STEP WELDMENT	SCALE
05.01.20	NEW ISSUE		NTS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.03.26	6.1	Weld 2nd end cap AS per DWG 03388 Inspect Alodine QC 3	FF 0604.05	06.04.03	3	[Signature]	[Signature]	
06.03.26	6.2	Weld 2nd end cap AS per DWG 03388, And grind welds flush. Inspect for foreign objects.		06.04.04	3			
06.03.26	6.3	Inspect QC 5/9		06/04/06	3			
06.03.26	6.4	Touch-up end cap with alodine as necessary AS per Q51005 4.1	SAD	06.04.08	3			
		change muscle					06.03.26	
06.03.26	7.	Make change to powder coat white permanent change				[Signature]	06.03.26	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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